

Date: Tuesday, 7/10/2007 1:05:54 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 33457		
Estimate Number	: 12784		
P.O. Number	: N/A	Part Number	: D35649
This Issue	: 7/10/2007	Drawing Number	: D3564 REV C
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 7/17/2007
Checked & Approved By	:	Qty:	30
Comment	: Est Rev:A New Issue 07-03-08 ec	Um:	Each
	: Est Rev:B As per Rev C 07-07-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.9177 sf(s)/Unit Total : 27.5310 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: M104725 HB 07-07-16 M103961		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ****(D3564-1F)**** Dwg Rev: C Prog Rev: C		
2-Deburr if necessary HB 07-07-16		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-07-16		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK En 07-07-17		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary MF 07-07-17 Form on Brake as per Dwg D3564 using Jigs DT and DT SAD 07/07/17		
Form Joggle as per Dwg D3564 on brake using Jig DT SAD 07/07/17		



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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Er 07/07/17 X31 *cont'd*

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat *M105258*
Weld hardcoat as per Dwg D3437

SL 07/07/28 8X
FC 07/07/27 Z1

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/30 ⑧

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/30 ⑧

10.0 POWDER COATING

POWDER COATING



M104864

8X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/08/03

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd

07/08/03

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

F-P18

m-l

07/08/07

13.0 QC21

FINAL INSPECTION/W/O RELEASE



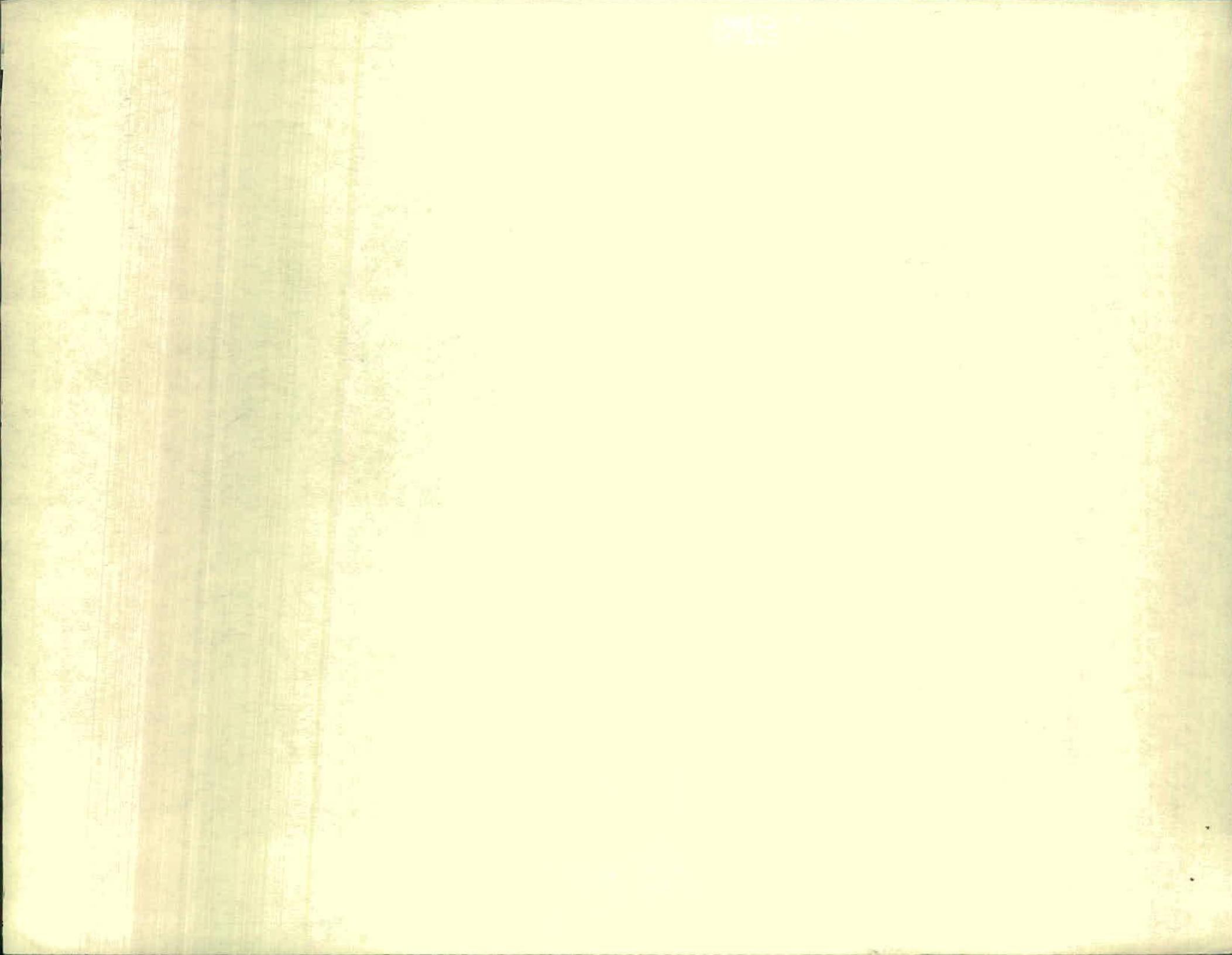
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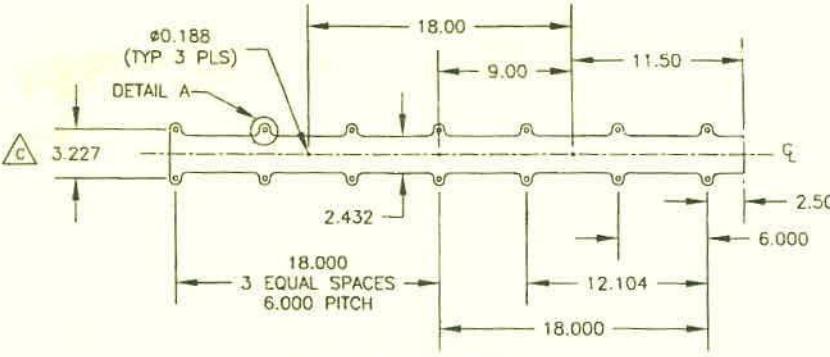
K 07/08/08

Job Completion

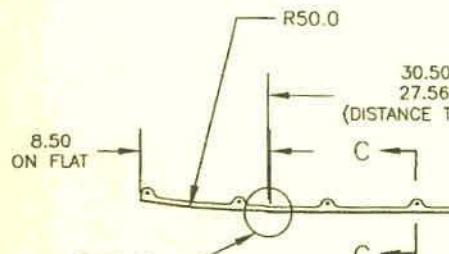


J 07-08-07



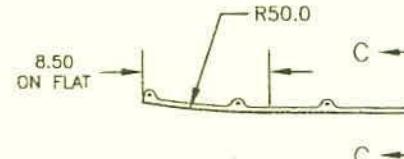


D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)

FOR -1 ONLY
DETAIL B



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

FOR -9 ONLY
DETAIL B

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07-06-28

NO 33457
WORK ORDER
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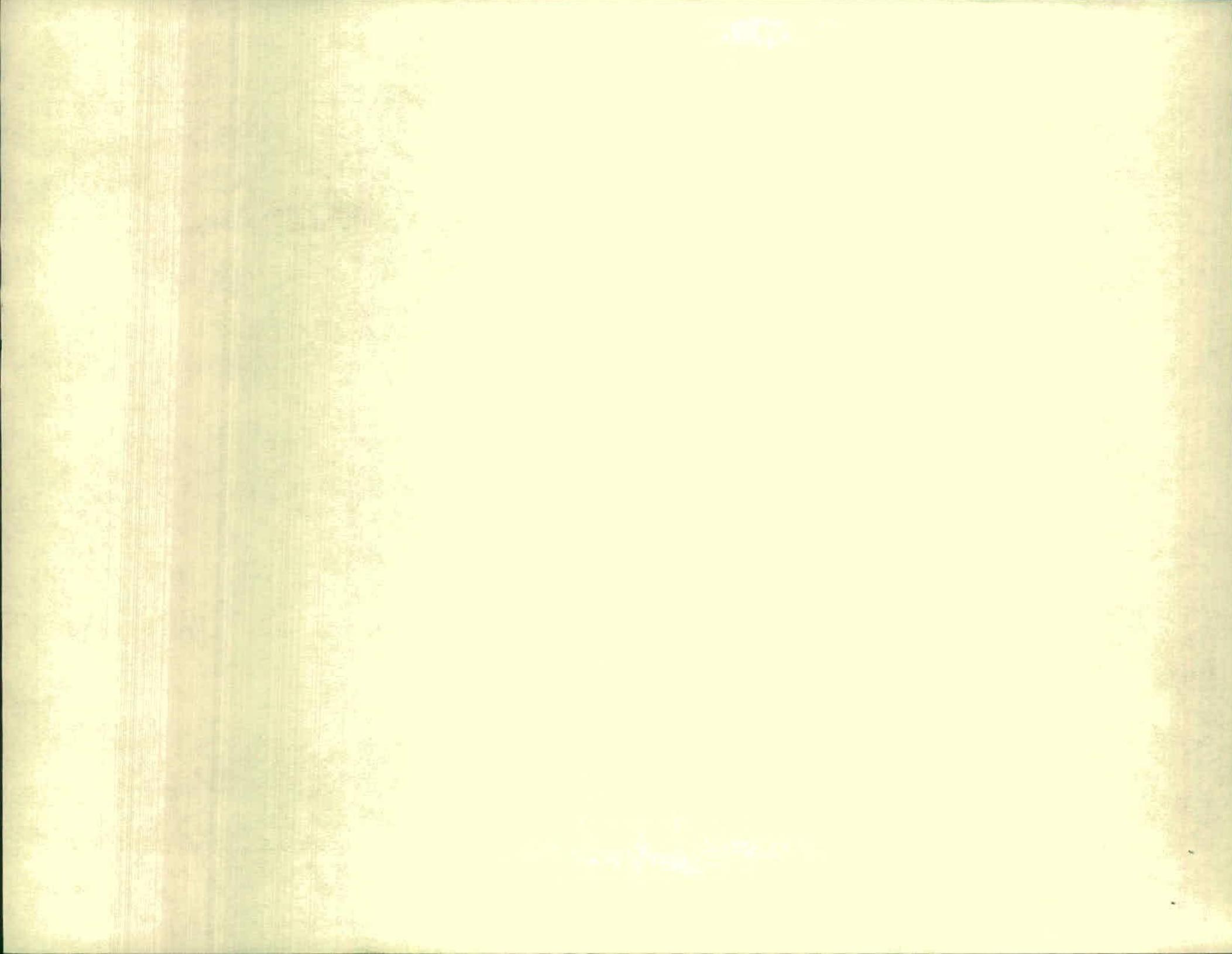
D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

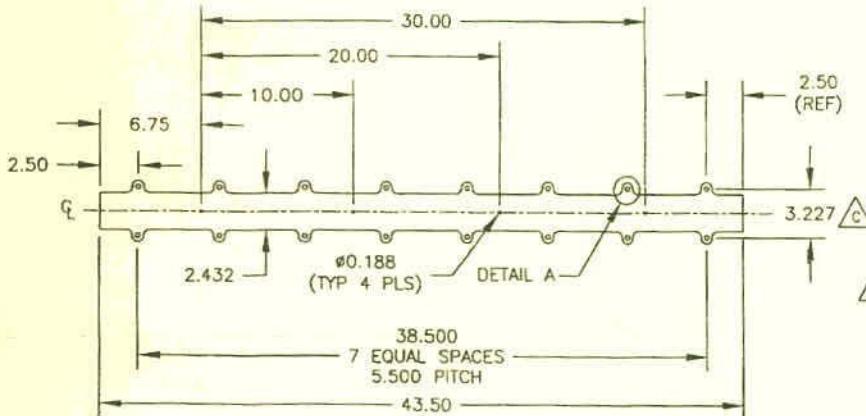
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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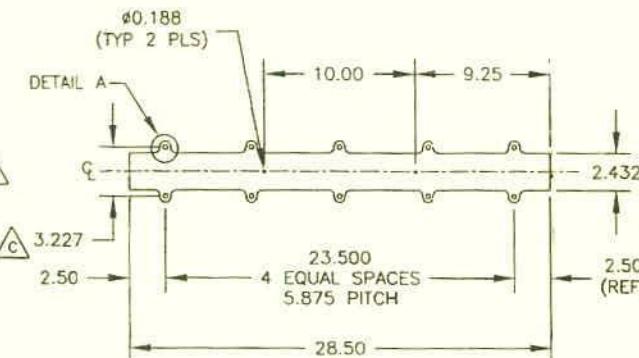
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3564
DATE 07-04-17	TITLE WEARSHOE	REV. C SHEET 1 OF 2 SCALE 1:8

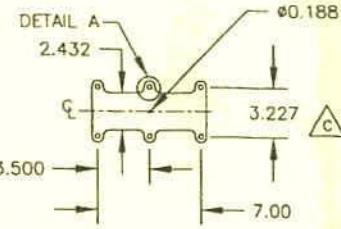




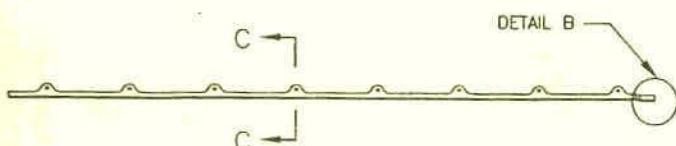
D3564-5F FLAT PATTERN



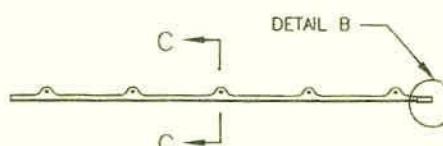
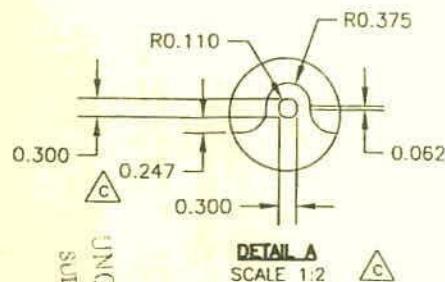
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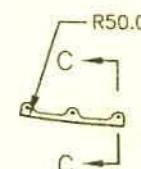
D3564-13F FLAT PATTERN



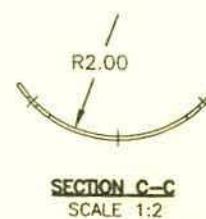
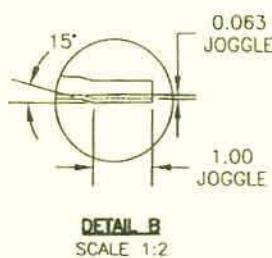
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



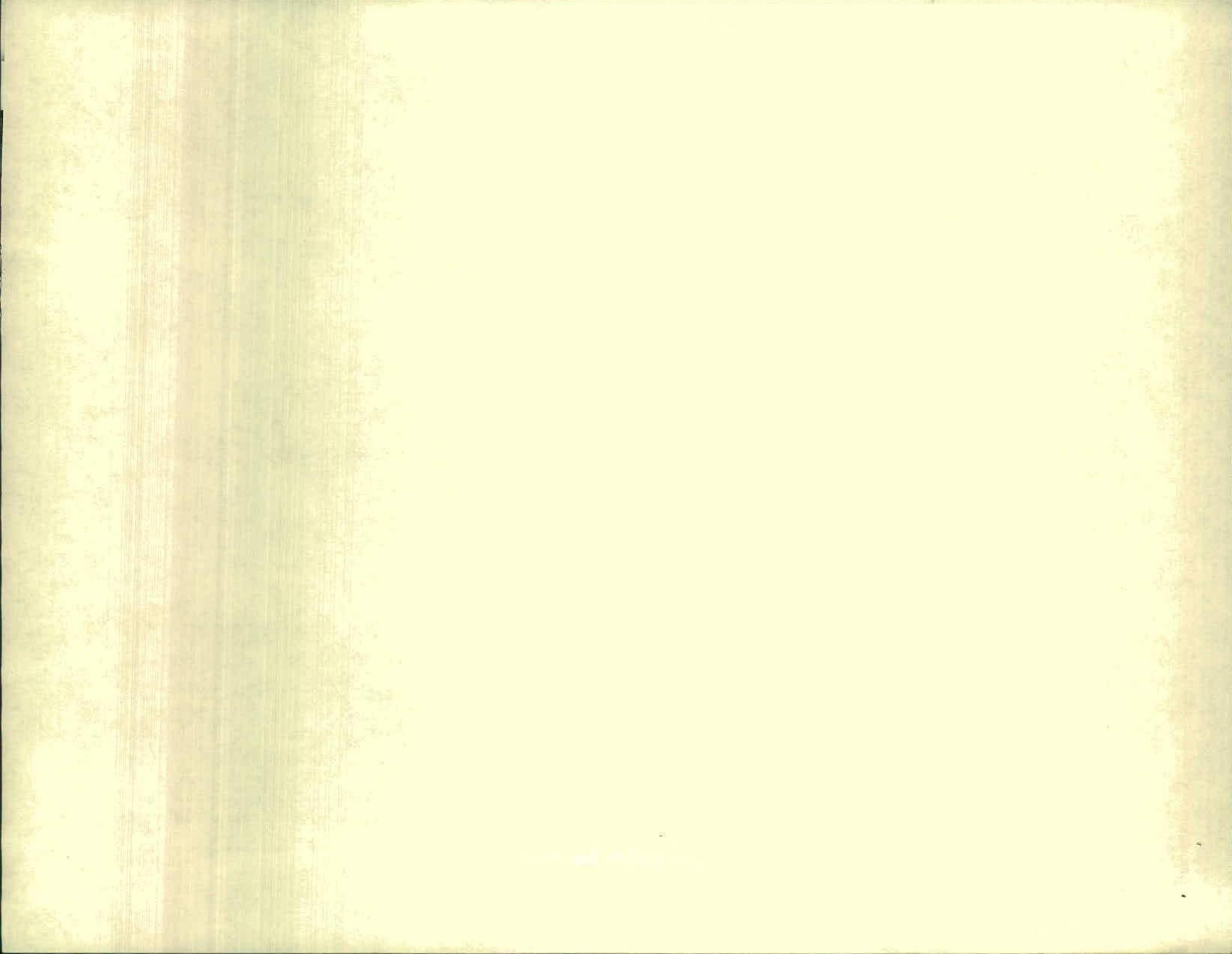
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



RELEASED
07/04/2017

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WORK ORDER
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	DATE 07.04.17		TITLE WEARSHOE	SCALE 1:8



DART AEROSPACE LTD

Work Order: 33457

Description: WEAR PAD

Part Number: D3564-9

Inspection Dwg:

Rev: C

Page 1 of 1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

1

Prototype

Measured by:

142

Audited by:

3

Prototype Approval:

Date:

87-07-16

Date:

57/57/17

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

